

AN 1998-370222 [32] WPIDS
DNN N1998-290128 DNC C1998-112950
TI Continuous hot rolling for manufacturing **steel** sheet with thin scale - involves **coiling steel** sheet obtained from **finish rolling** carried out at ultimate prolonged pressure and predetermined speed after **quenching** at predetermined temperature.

DC M21 M24 P51

PA (YAWA) NIPPON STEEL CORP

CYC 1

PI JP (10146601) A 19980602 (199832)* 6

ADT JP 10146601 A JP 1996-318530 19961115

PRAI JP 1996-318530 19961115

AB JP 10146601 A UPAB: 19980812

The hot rolling method involves removing primary scale during **rough rolling**. At least one time inversion of **rough rolled** sheet front to back is done between subsequent rolls. After turning the edges of front and back of preceding and following **rough rolled** sheets a front to rear inversion is done before welding and **finishing rolling** after welding. The final stages of **finishing roll** is done using high speed **steel** rollers for active online **roll grinding**. **Finishing roll** is done at an ultimate prolonged pressure and speed of 800 m/min. **Coiling** is effected after **quenching** at 550-360 deg. C.

ADVANTAGE - Produces thin scale **steel** sheets.

Dwg.1/2